

Work Order ID 70594

Monday, June 13, 2011 11:25:10 AM



Page 1

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA588 & DWG D3443
FOLIO REV: *[Signature]*
DWG REV: *[Signature]*
2-DEBURR AS REQUIRED

20 11-6-24

4

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

20 11-6-24

4

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

20 11/06/24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70594

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Page 2

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Identify as per dwg & Stock Location: W/A 22 0.00

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

Pl 11-06-27

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/27MC
11-06-27

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:25:16 AM

Page 1

Work Order ID: 70594



Parent Item: D3443-3



Parent Item Name: Clevis

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A ☐ 05.11.14 ☐ New issue ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R1.500

Purchased

No

100

f

13.5180

0.25

1



20 11-6-21

304 round bar 1.500

Location

Loc Qty

Loc Code

MAT029

13.518

1.416

106260

1.688

114676

11.83

1.416
25

1.688

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D3065-5DART AEROSPACE LTD		Work Order:	70594
Description: Clevis		Part Number:	D3443-3
Inspection Dwg: D3443	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.704	/			
0.95	+/-0.030	.952	/			
Ø0.500	+0.000/-0.005	.4975	/			
20°	+/-0.5°	20°	/			
R0.450	+/-0.010	R.450	/			
Ø0.375	+0.006/-0.001	.377	/			
0.451	+/-0.010	N/A	/			
0.625	+/-0.010	.622	/			
1.43	+/-0.030	1.435	/			
0.720	+/-0.010	.719	/			
0.05 x 45°	+/-0.5°	.05 x 45°	/			
45°	+/-0.5°	45°	/			
1.00	+/-0.030	1.000	/			
1.125	+/-0.010	1.125	/			
0.438	+0.005/-0.000	.442	/			
R0.219	+/-0.010	R.219	/			

Measured by:	RP	Audited by:	AM	Prototype Approval:	N/A
Date:	11.6.24	Date:	11/06/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev C	KJ	M

W/O:		WORK ORDER CHANGES					
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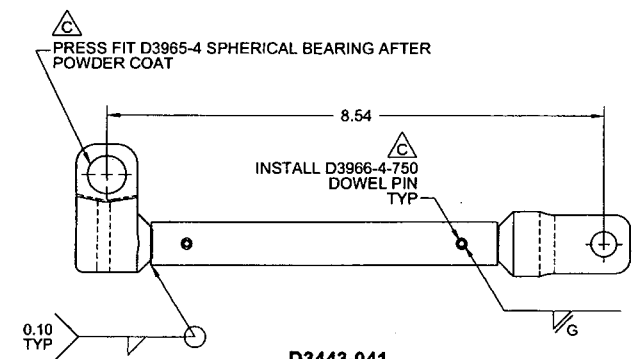
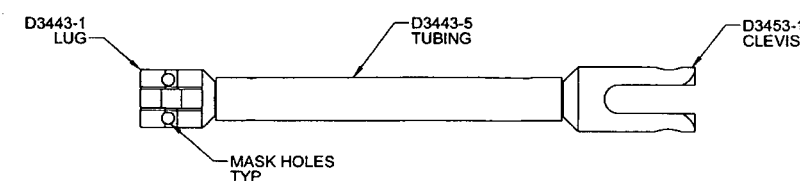
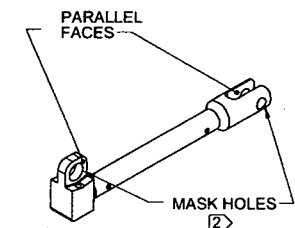
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 70594
PL 11/06/13

RELEASED
09/06/25 MP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2): 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.561 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C8-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE: & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3443	REV. C SHEET 1 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE STRUT WELDMENT ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	09.06.25		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

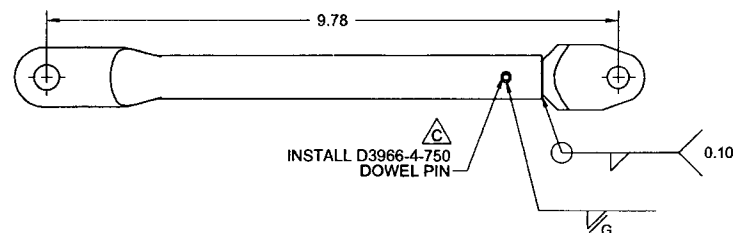
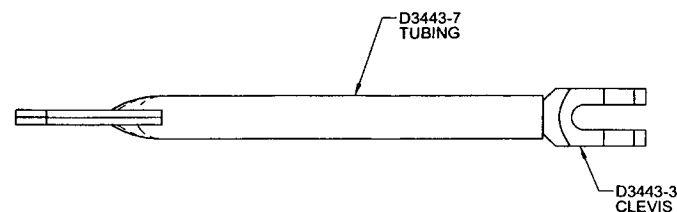
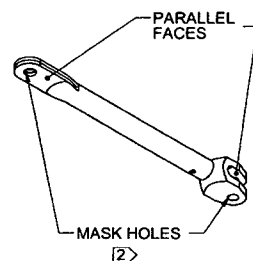
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN

u/070594



D3443-043

RELEASED
09/06/25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3443	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE STRUT WELDMENT ASSEMBLY	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	SCALE	
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

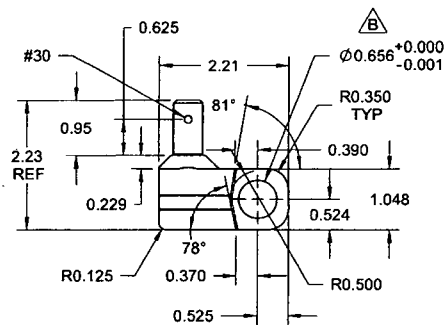
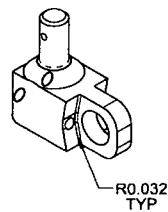
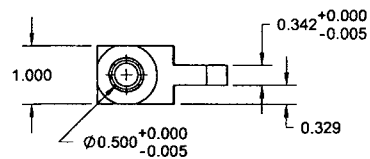
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

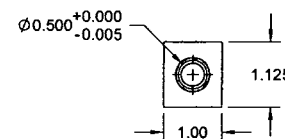
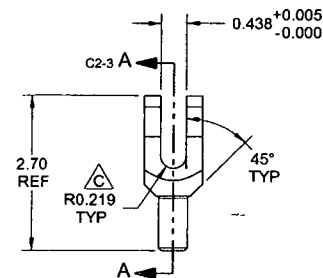
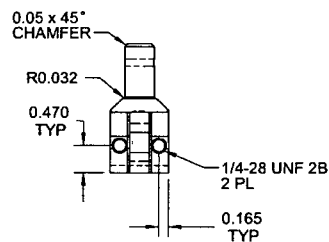
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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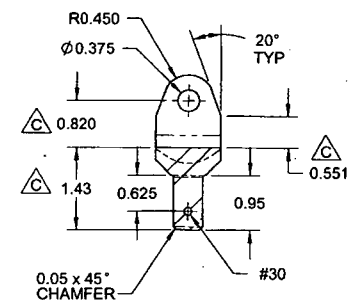


D3443-1 LUG



D3443-3 CLEVIS

u/u 70594





SECTION A-A C4-3

RELEASED
09/06/25/14

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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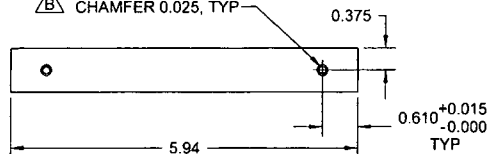
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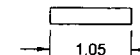
NOTE: Date & initial all entries

DRILL $\phi 0.125$ THRU
CHAMFER 0.025, TYP



D3443-5 TUBING

$\phi 0.210^{+0.005}_{-0.010}$

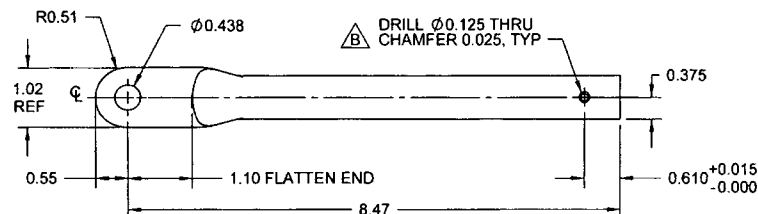
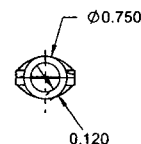
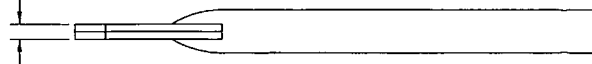


D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

$0.260^{+0.000}_{-0.030}$






D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
01/23/25

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
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